

Date: Monday, 2/11/2008 2:12:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	ARM
Job Number	37339			Part Number	D2845
Estimate Number	11668			Drawing Number	D2845 REV A
P.O. Number				Project Number	N/A
This Issue	2/11/2008	S.O. No.		Drawing Revision	A
Prsht Rev.	NC			Material	
First Issue	/ /	Type	MACHINED PARTS	Due Date	2/18/2008
Previous Run	36089			Qty:	20
Written By	<i>KJ 08 02 11</i>			Um:	Each
Checked & Approved By					
Comment	Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
		Comment: Qty.: 1.6109 f(s)/Unit Total : 32.2182 f(s) 304 RD Tube .500 x .035W M304TR0500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 17.11" long (Hole ctr. to hole ctr.) using Jig DT 8012* Batch M 107098 (13) M 106593 (8) 88 08/02/12 (20)
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Form per Dwg D2845 using brake and bending Jig DT 8238-C Deburr D 08/02/12 (20) DAD 08/02/17 20
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP J 08/02/15 (20)
4.0	POWDER COATING	POWDER COATING
		m 107085 Fx 08/02/19 (20)
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3.
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION J 08-02-19 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 37339

Part Number: D2845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

205

8/2/08 SP 202

7.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

2008/2/22

Job Completion



2008/2/20

20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

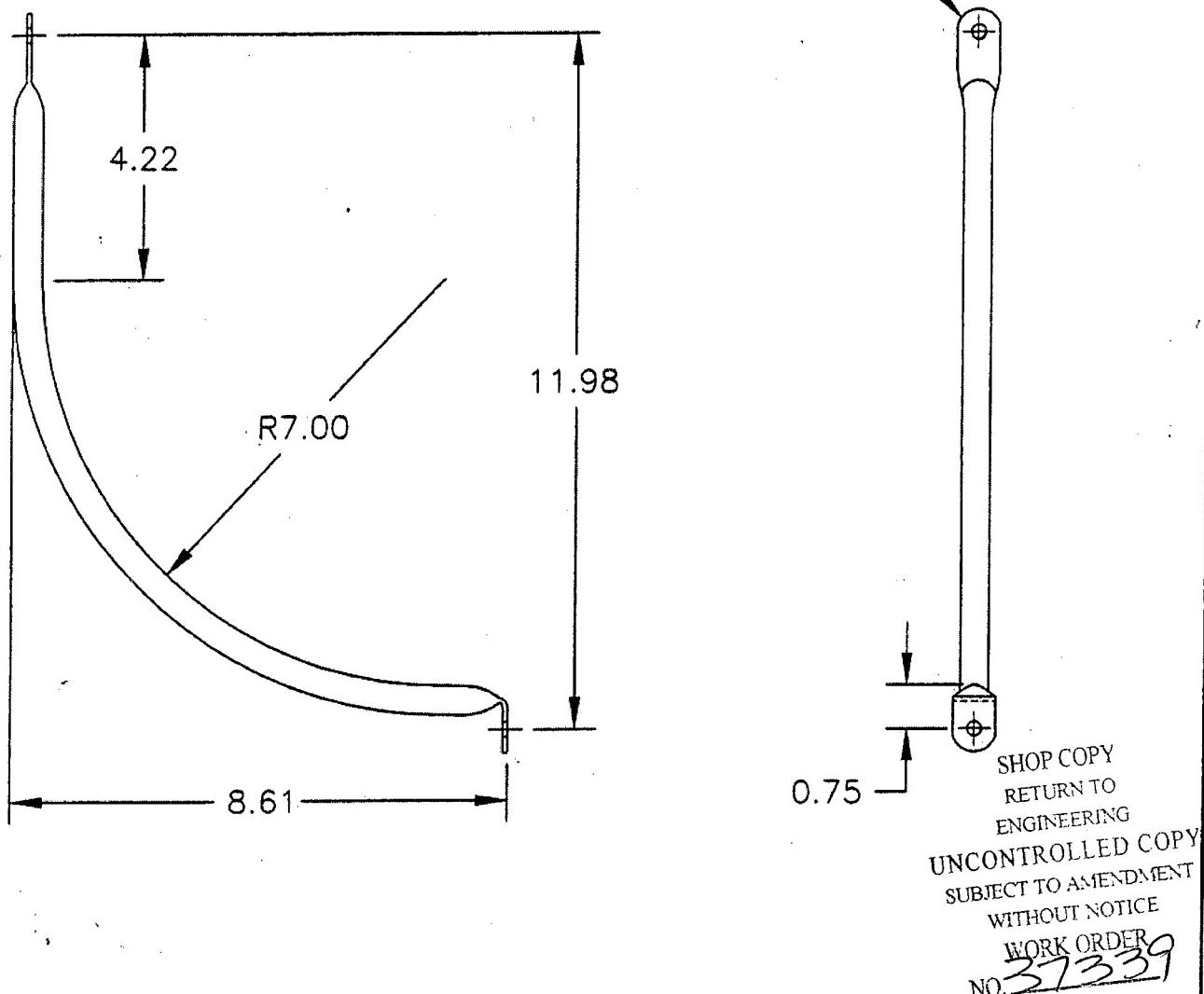
NOTE: Date & initial all entries



DESIGN RE	DRAWN BY RE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2845
DATE 98.10.14	TITLE ARM	REV. A SHEET 1 OF 1 SCALE 1:3
A	98.10.14	NEW ISSUE

RELEASED  
06.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE,  $\varnothing 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3